

Date: Tuesday, 24/06/2008 3:42:37 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : PLUG
 Job Number : 40048
 Estimate Number : 10930
 P.O. Number :
 This Issue : 24/06/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D2057
 Drawing Number : D2057 REVC
 Project Number : N/A
 First Issue : 1/1 Type : MACHINED PARTS Drawing Revision : C
 Previous Run : 39826 Material :
 Due Date : 24/06/2008 Qty: 200 Um: 100 Each
 Written By :
 Checked & Approved By : JUP 08.6.24
 Comment : Est D 02.08.22 Make in Cobra - KJ
 Est Rev:E 08-05-27 as per ECN1195P DD verified by:EC
 Est Rev:F 08-06-04 Added QC8 JLM Verified By:EC
 Est Rev:G 08-06-20 rev.D as per dwg DD verified by:EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6R0750 6061-T6 Round Bar .750"



Comment: Qty.: 0.1050 f(s)/Unit Total : 10.5000 f(s)
 6061-T6 Round Bar .750"
 Material: 6061-T6 (QQ-A-225/8) Ø0.75 Rod
 (M6061T6R0.750) Batch M103857

J.F. 08/06/25 (203)

2.0 HARDINGE HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL
 Make as per Dwg D2057 and Folio FA260.
 Break all sharp edges 0.015 max.Do not drill Ø0.191

J.F. 08/06/25 (203)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 08/06/25 (203)

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

RP 08/06/25 (203)

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 Identify and Stock
 Location: 10

8/6/26

(203)
 SP

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Date: Tuesday, 24/06/2008 3:42:37 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLUG

Job Number: 40048

Part Number: D2057

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/07/01 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



JLD 08-6-28

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

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|------------------------------|---------------|---------------------------|
| DART AEROSPACE LTD | | Work Order: 40048 |
| Description: Plug | | Part Number: D2057 |
| Inspection Dwg: D2057 | Rev: B | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|------------------------|----------------|------------------|--------|--------|----------------------|----------|
| 1.15 | +/-0.030 | 1.150" | ✓ | | | |
| 0.15 | +/-0.030 | .149" | ✓ | | | |
| 0.75 | +/-0.030 | .748" | ✓ | | | |
| 0.030 x 45° | +/-0.010 | .025" | ✓ | | | |
| 0.435-0.425 | N/A | | | | | |
| 0.36 | +/-0.030 | | | | | |
| Ø0.191 | +0.005/-0.001 | | | | | |
| .397-402 | N/A | .399" | ✓ | | | |
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| Measured by: J.F. | Audited by: J.L. | Prototype Approval: | N/A |
| Date: 08/06/25 | Date: 08/06/25 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|------------------|------------|----------|
| A | 05.02.17 | New Issue | KJ/JLM | |
| B | 07.11.26 | Dimensions added | KJ/EC/DD | |

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NOTE: Date & initial all entries

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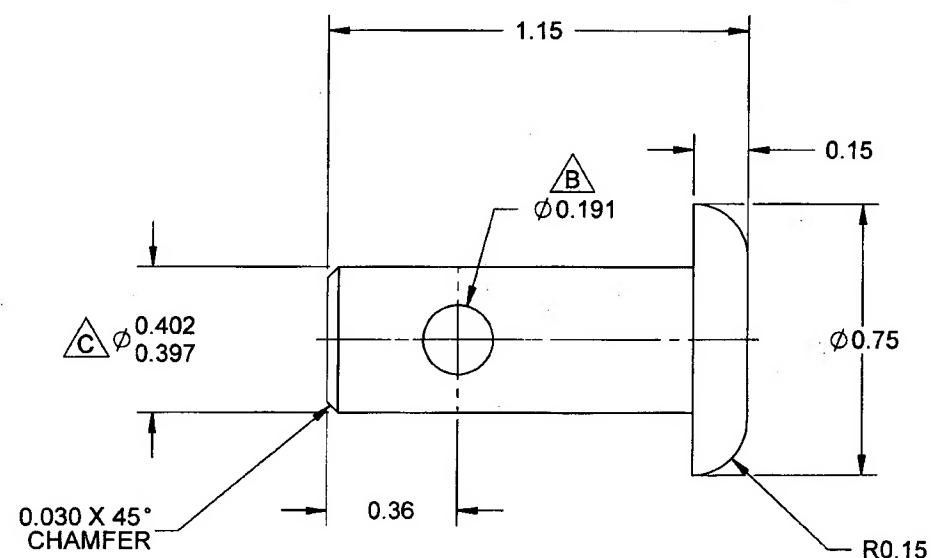
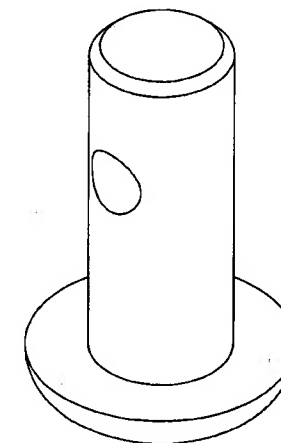
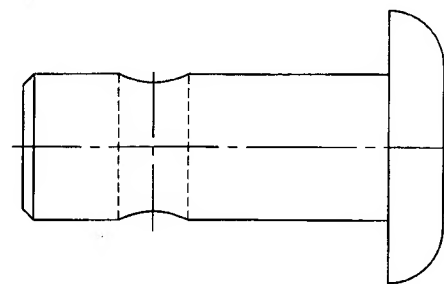
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**D2057 PLUG**

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40048

RELEASED
08-06-10

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ROUND BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF DART SPEC M6061T6R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

| C | $\phi 0.402 / \phi 0.397$ WAS $\phi 0.430 / \phi 0.425$; REASON: ID OF D2010-103/-104 DECREASED TO $\phi 0.402$ | PH | 08.06.10 |
|------------|------------------------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| B | REDRAWN; $\phi 0.191$ WAS $\phi 0.187$ (TSR A1100) | CP | 98.10.15 |
| A | NEW ISSUE | JB | 92.03.13 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | JB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | JB | | |
| CHECKED | JB | DRAWING NO. | REV. C |
| MFG. APPR. | JB | D2057 | SHEET 1 OF 1 |
| APPROVED | JB | TITLE | SCALE |
| DE APPR. | JB | PLUG | NTS |
| DATE | 08.06.10 | COPYRIGHT © 1992 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |